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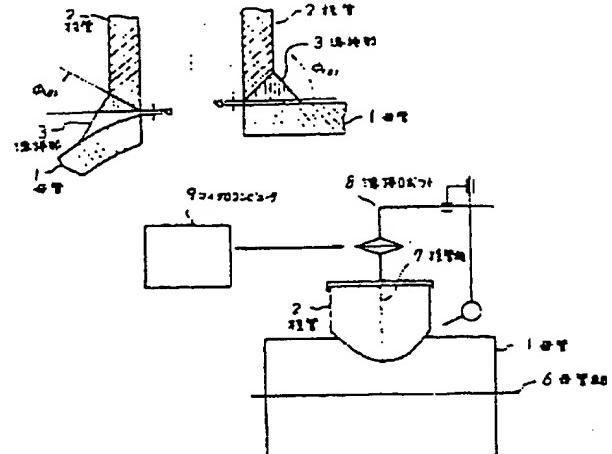
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TITLE : SADDLE-TYPE WELD LINE WELDING
 METHOD FOR PIPE INTERSECTION
 PART



$$(3) \quad \phi(\theta) = \tan^{-1} \left(\tan \phi_0 - \frac{2}{t} \sqrt{R^2 - (r-t)^2} \sin^2 \theta + \frac{2}{t^2} \right)$$

$$f_{r-1}^r \sqrt{R^2 - x^2 \sin^2 \theta} dx$$

ABSTRACT : PURPOSE: To improve the welding workability by fixing a groove cross section between the branch pipe groove face and the base pipe surface extending over a full circle of a joint to perform the welding.

CONSTITUTION: A bevel angle ϕ of a branch pipe 2 is expressed with a formula 1 as a function of its coordinate angle θ and a welding robot 8, a microcomputer 9, etc., are arranged in combination. The lower edge of the branch pipe 2 is formed to a shape having the level angle ϕ based on the formula 1 via an NC gas cutting machine, etc., and then, the edge penetration along the base pipe outside diameter is carried out. The groove shape dimensions such as a groove width, a groove angle, etc., in case the branch pipe 2 is fitted to the base pipe 1 and the tack welding is performed are calculated. Next, the object position of the welding at the time of the automatic welding via a robot 8 and a computer 9 is calculated to perform the welding. By this method, since the welding with the fixed groove cross section is performed, the full-circled welding can be performed with the same number of beads. Accordingly, the welding workability is improved.

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